

D 412-742-043

12

Date: Wednesday, 2/20/2008 4:11:51 PM
 User: Kim Johnston

Process Sheet

Customer: : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE
 Job Number : 37503
 Estimate Number : 10366
 P.O. Number :
 This Issue : 2/20/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : LANDING GEAR
 Previous Run : 35745
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 05-10-13 New Issue KJ/JLM
 Est Rev: B 06-06-08 As per DSI9336 JLM
 Est Rev: C 07-12-03 ECN 1072 DD verified by: JLM

Part Number : D412742013
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 3/17/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



AS 08.02.27

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG004

AS 08/03/13

2.0 37503A FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY

D412-742-043 B

375034

sl

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D2571 Saddle, Fwd; Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2571 Saddle Fwd Outside

36322

AS

08/03/12

5.0 D2572 Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2572 Saddle Fwd Inside

37283

AS

08/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:11:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 37503

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2573

Saddle Aft Outside

35933

AS 08/03/12 (X)

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2574

Saddle Aft Outside

37567

AS 08/03/12 (X)

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2876

Saddle Spacer

33543

AS 08/03/12 (X)

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2877

Saddle Spacer

36276

AS 08/03/12 (X)

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D3403-1

Bushing

35034

AS 08/03/12 (X)

11.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2747

Bolt

B36331

AS 08/03/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:11:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 37503

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D35331	Set Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Set Screw

B 28093

AS 08/03/12

(X)

13.0	AN4C6A	Bolt
------	--------	------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Pick:

Qty	Part Number	Description
16	AN4C6A	Bolt

Batch

~~AN4C~~

M100519

AS 08/03/12

(X)

14.0	AN4C52A	BOLT
------	---------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty	Part Number	Description
8	AN4C52A	Bolt

Batch

M19512

AS 08/03/12

(X)

15.0	AN6C12A	BOLT
------	---------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty	Part Number	Description
8	AN6C12A	Bolt

Batch

M104289

AS 08/03/12

(X)

16.0	D36723	PHENOLIC WASHER
------	--------	-----------------



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
PHENOLIC WASHER

B 34471

AS 08/03/12

(X)

17.0	AN960C416L	WASHER
------	------------	--------



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
WASHER

M105793

AS 08/03/12

(X)

18.0	D36729	PHENOLIC WASHER
------	--------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PHENOLIC WASHER

B 35523

AS 08/03/12

(X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:11:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 37503

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960C616L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER M18918

AS 08/03/12 (X)

20.0

D367211

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
PHENOLIC WASHER B35524

AS 08/03/12 (X)

21.0

MS210434

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
Nut M107101

AS 08/03/12 (X)

22.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M106302

AS 08/03/12 (X)

23.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty Part Number
8 D3403-3

Description
Bushing

Batch

B35635

AS 08/03/12 (X)

24.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty Part Number
1 D3405-041

Description
GHW Lug

Batch

B35779

AS 08/03/12 (X)

25.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty Part Number
1 D3405-043

Description
GHW Lug

Batch

B34841

AS 08/03/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:11:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 37503

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

M19529

AS

08/03/12

(XU)

27.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4 Nut

M107101

AS

08/03/12

(XU)

28.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-041

TOW RING

B35780

AS

08/03/12

(XU)

29.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

B33519

AS

08/03/12

(XU)

30.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

B33276

AS

08/03/12

(XU)

31.0

AN3C37A

BOLT



Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s)

BOLT

M100169

AS

08/03/12

(XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:11:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 37503

Part Number: D412742013

Job Number:



Seq. #: Machine Or Operation: Description :

32.0 AN3C40A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT

M106169

AS 08/03/12 (X)

33.0 AN3C41A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT

M106176

AS 08/03/12 (X)

34.0 AN3C42A BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT

M106169

AS 08/03/12 (X)

35.0 AN3C43A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT

M106227

AS 08/03/12 (X)

36.0 AN3C46A BOLT



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOLT

M106169

AS 08/03/12 (X)

37.0 AN960C10L washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
washer

M107008

AS 08/03/12 (X)

38.0 MS210433 Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut

M107214

AS 08/03/12 (X)

39.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/03/13 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:11:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 37503

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location:

~~Rev E~~ Rev E

AS 08/03/13 SD (1)

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/03/14 (1)

Job Completion



2008/3/13 (1)

B37503A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-742-013

12

Date: Wednesday, 2/20/2008 4:12:03 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKID ASSEMBLY
 Job Number : 37503A
 Estimate Number : 10756
 P.O. Number :
 This Issue : 2/20/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412742043
 First Issue : 1 / 1 Type : LANDING GEAR Drawing Number : D3391
 Previous Run : 35745A Drawing Revision : G
 Material :
 Due Date : 3/17/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 08 02 21
 Comment : Est Rev A 05.10.13 New Issue KJ/JLM
 Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 Est Rev C 07-05-28 As per Rev F JLM
 Est Rev D 07-12-04 ECN 1072 DD verified
 by:JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003

N/A 72

2.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M100005

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M105585Expiry date: 08-07

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M100251A/R Sikaflex-241/-291 M105585Expiry date: 08-07

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

08-05-08 (X1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:12:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 37503A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-023 Mid Tube Assembly

B35767

JS

4.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-025 Aft Tube Assembly

B36841

JS

5.0

D35641

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B33243

JS

6.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B337410

JS

7.0

D35643

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B33764

JS

8.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B37212

JS

9.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B37411

JS

08-03-11

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 08/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:12:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 37503A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: M107008

9/16

11.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: M105300

9/18

12.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: M105906

9/11

13.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

washer

Batch: M107242

9/11

08-03-12

(X1)

14.0

QC5

INSPECT WORK TO CURRENT STEP:



Comment: INSPECT WORK TO CURRENT STEP

08/03/12 (X1)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: PP

PPP Rev: 37503

PP

37503

8/3/13 SD

(1)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/14

Job Completion



run 2008/3/13

(1)

Dart Aerospace Ltd

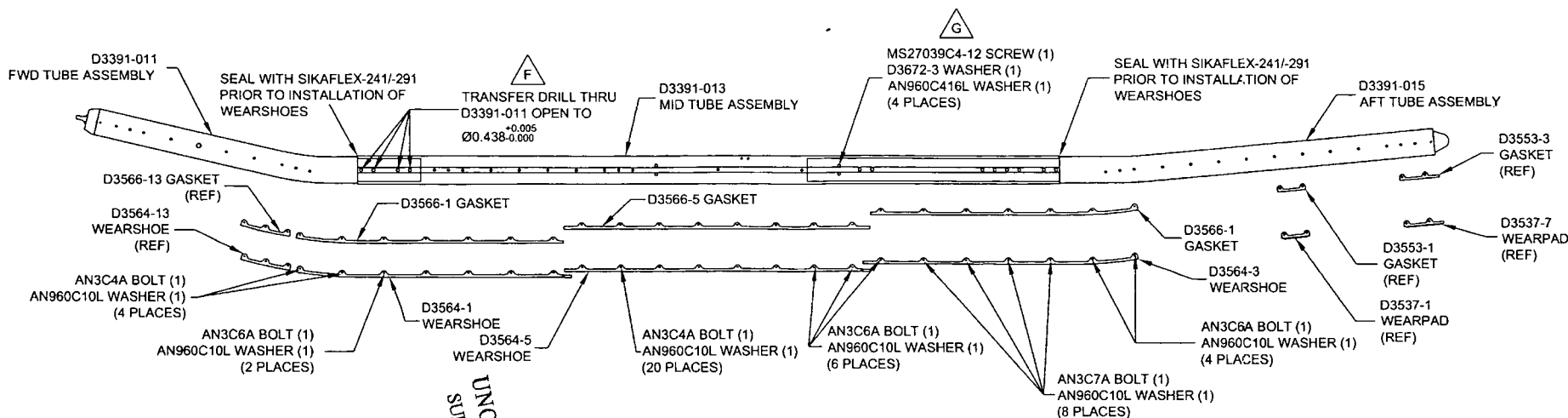
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041 ASSEMBLY

RELEASED
07-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

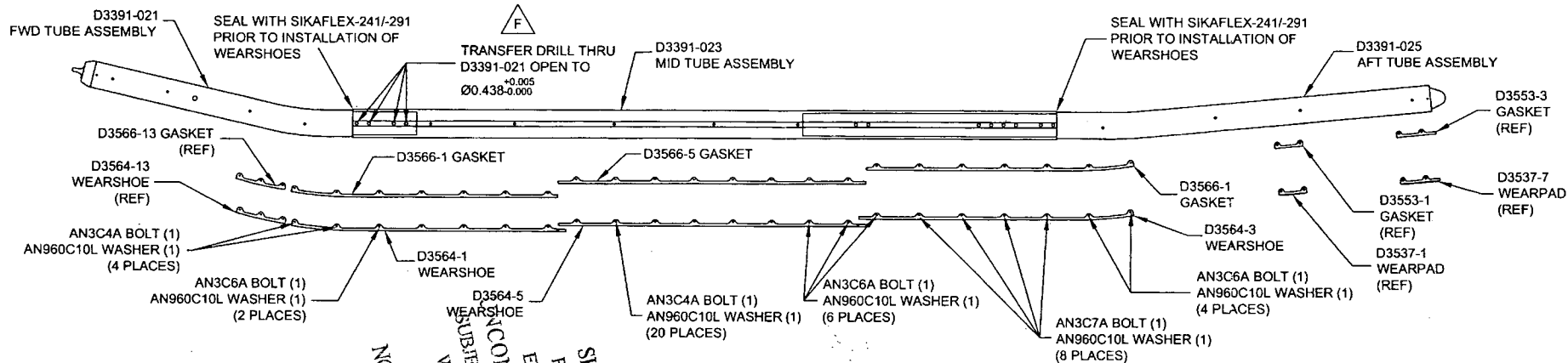
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 75034

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWJ SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	DE		
CHECKED	DE		
MFG. APPR.	DE		
APPROVED	DE		
DE APPR.	DE		
DATE	07.07.31		

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D3391
REV. G
SHEET 1 OF 8
TITLE 412 FLOAT SKIDTUBE
SCALE NTS
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D3391-043 ASSEMBLY

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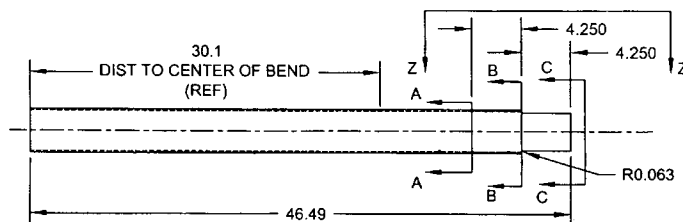
D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

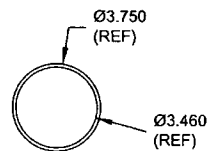
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

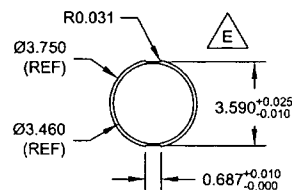
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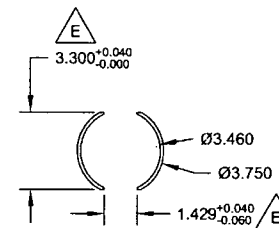
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



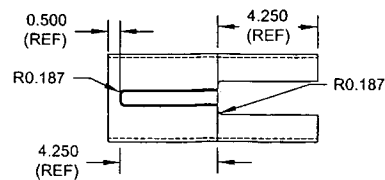
SECTION A-A
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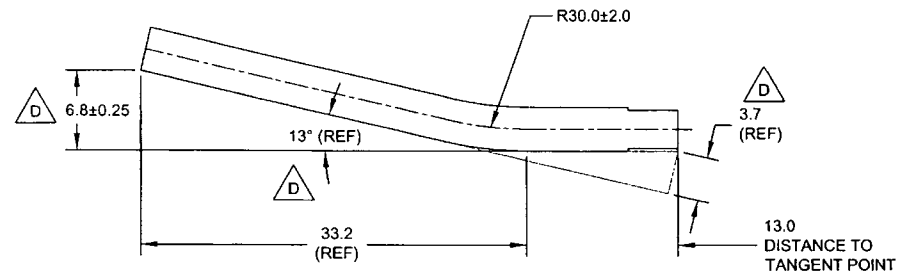
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SECTION C-C
(SCALE 1:5)



VIEW Z-Z
(SCALE 1:5)

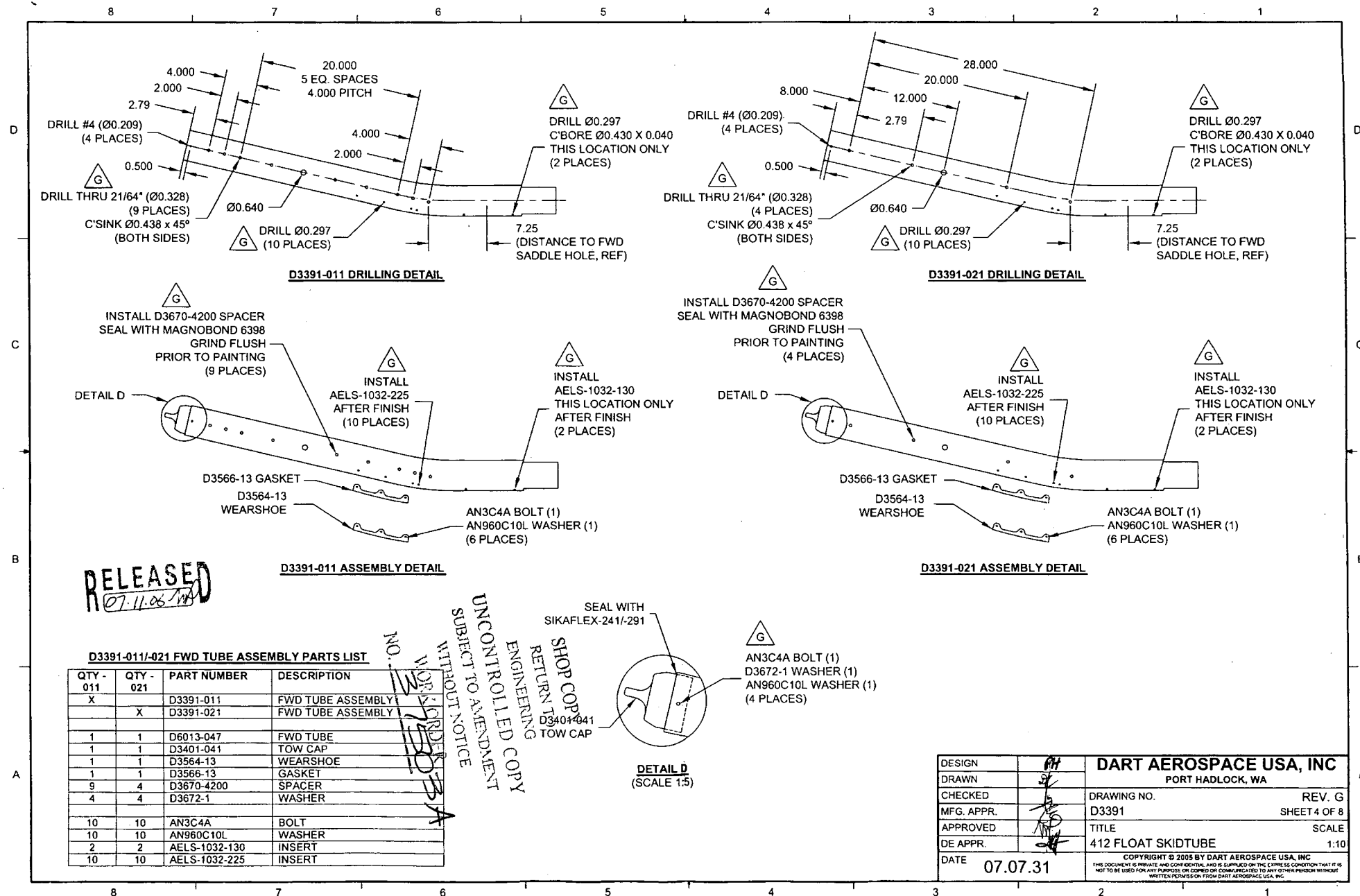


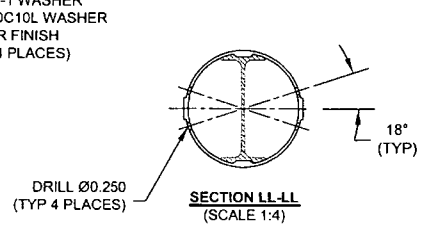
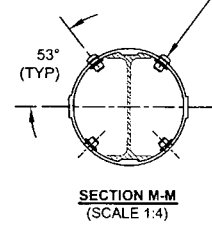
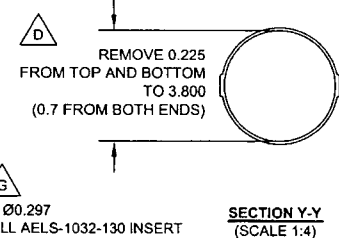
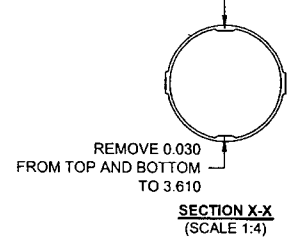
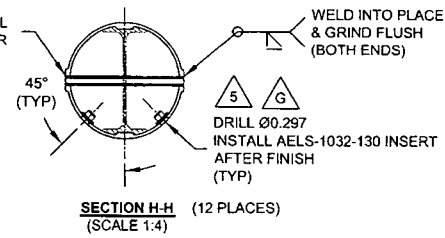
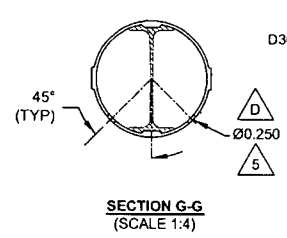
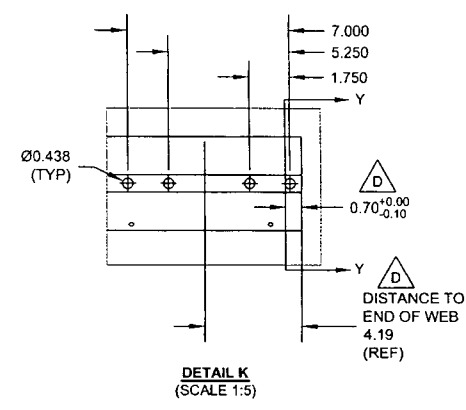
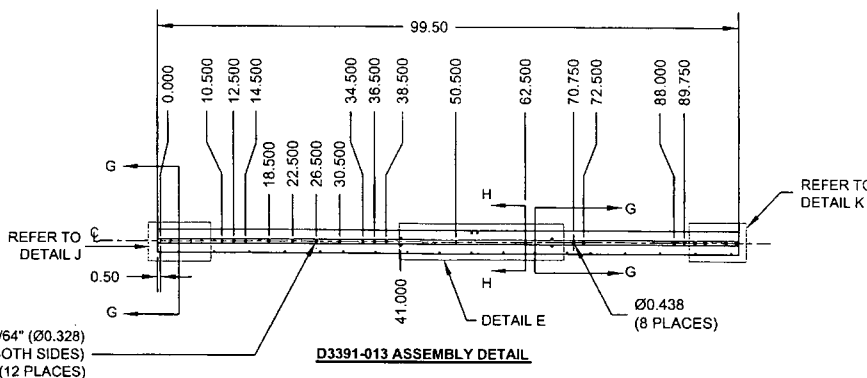
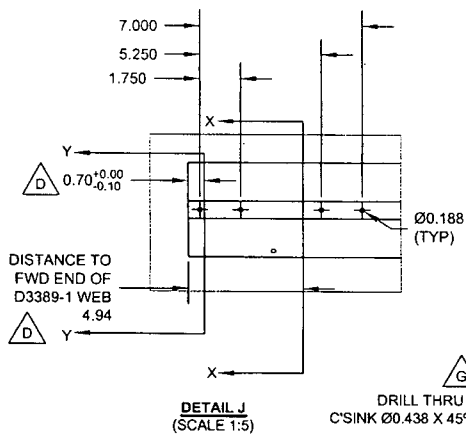
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)

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07-11-06 11P

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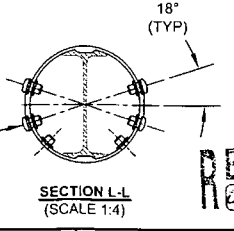
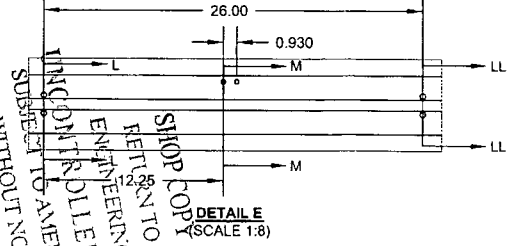
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MFG. APPR.	SLC		SHEET 3 OF 8
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DE APPR.	SLC		
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

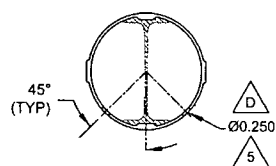
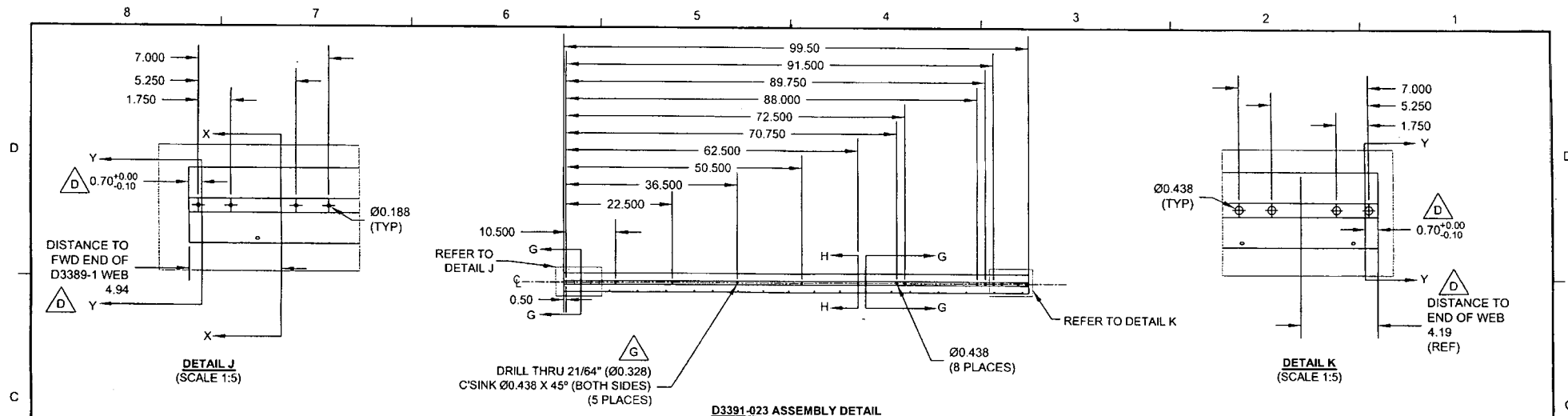


- D3391-013 MID TUBE ASSEMBLY**
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
 - WELDING: PER DART QSI 004

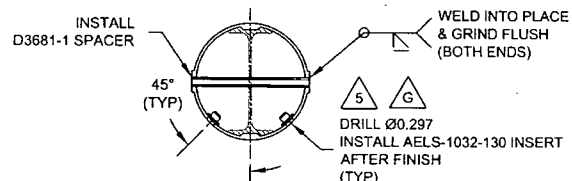
DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
(TYP 4 PLACES)

RELEASED
7-11-2017

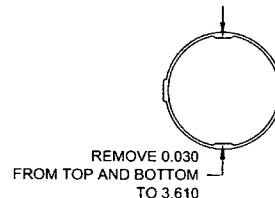
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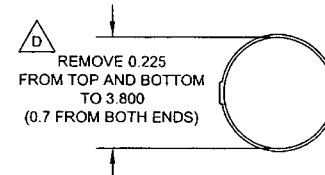
SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)



SECTION X-X
(SCALE 1:4)



SECTION Y-Y
(SCALE 1:4)

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

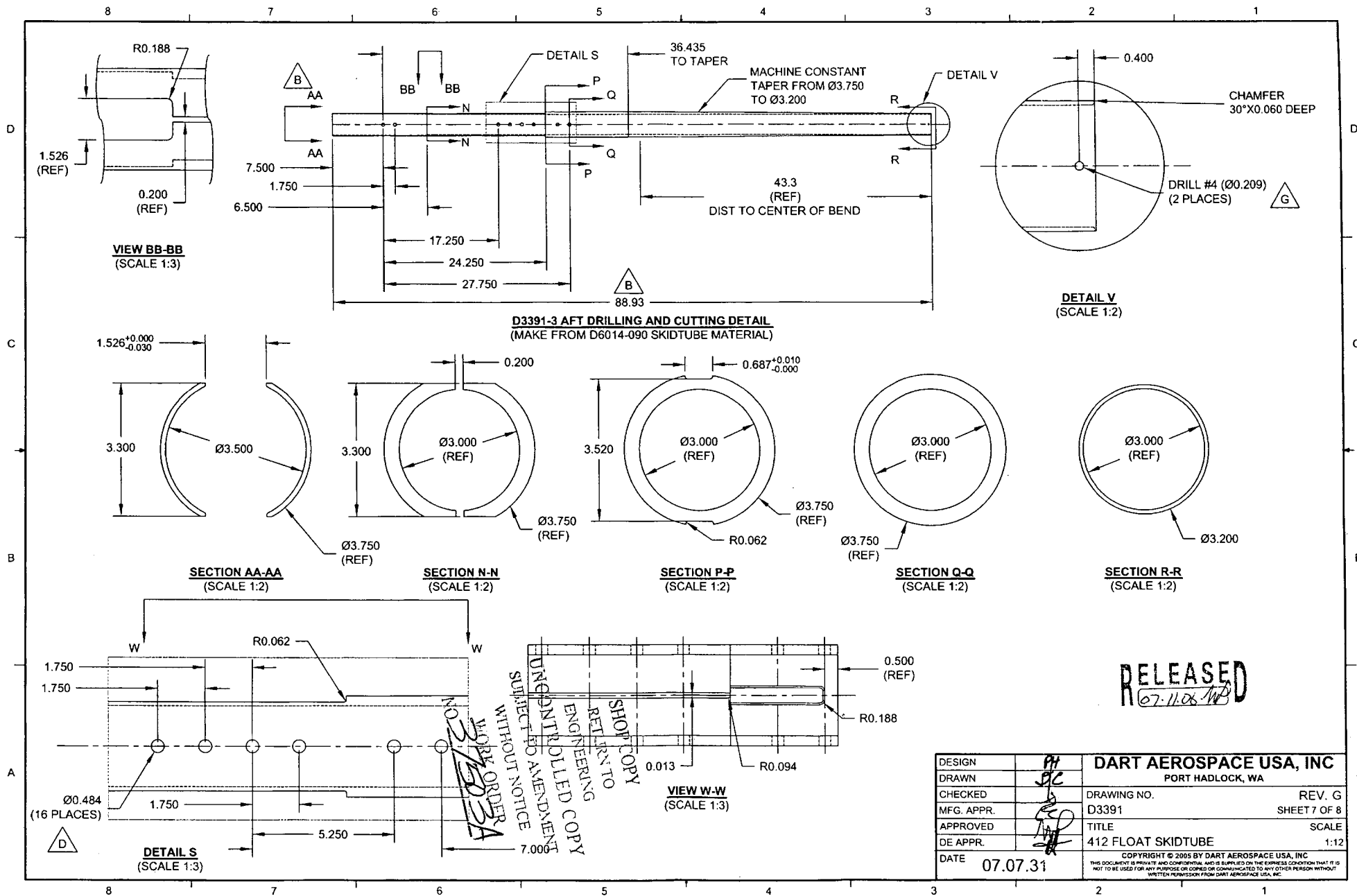
D3391-023 MID TUBE ASSEMBLY

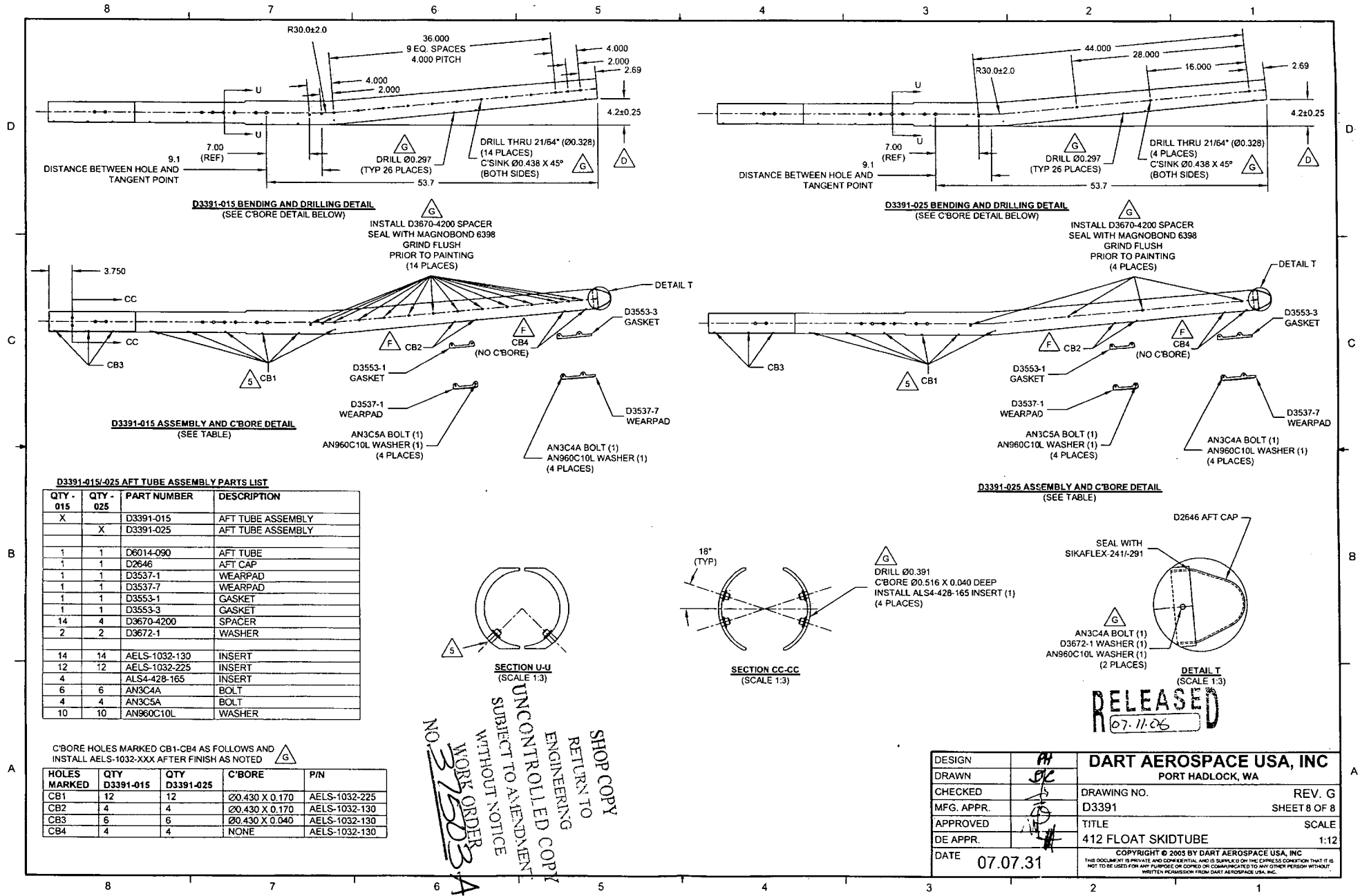
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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